

Work Order ID 86194

86194

Page 1

June-22-12 1:55:46 PM

Item ID: D2362-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Support Bracket

Start Date: 22/06/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 06/07/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/06/12

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2362	Rev E1

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA800 Rev: AA & Dwg D2362 Rev: E1 2-Deburr
per dwg D2362

12/07/08

12

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

12/07/08

12

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

12/07/08

5/4

12-07-09

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

130

Small Fab

Small Fab

0.00

OK 12/07/09

0.00

12 0

Memo

Small Fab

Debur

140

140

Powdercoat

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

Powder Coating

START TIME:

2:45

OVEN TEMPERATURE:

FINISH TIME:

3:15

12x 0 MK 12/07/09

150

150

QC

QC3- Insp Part Finish

0.00

Memo

Quality Control

0.00

0 0 R 1279

M121481

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Stop *NS2*

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12

Cust Item ID:

Required Date: 06/07/2012 **Req'd Qty:** 12.00

12

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: Date: Tooling: Date:

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

0.00

160

Small Fab

0,00

Small Fab

Memo

Small Fab

Bond rubber D2397-1 followed by D2397-3 using contact cement as per Dwg D2362
Batch M129 346

Batch M122346

0.00

170

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

Quality Control

0.00

180

Identify as per dwg & Stock Location: 484

0.00

Packaging

Memo

Packaging

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Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

MLJ 12/07/11

MLJ 12/07/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

June-22-12 1:55:49 PM

Page 1

Work Order ID: 86194

86194

Parent Item: D2362-3

D2362-3

Parent Item Name: Support Bracket

Start Date: 22/06/2012

Required Date: 06/07/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: G00.05.18 Added inspection level 8EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2397-3		Manufactured	No			100	Each	0.0000	1	12			
D2397-3					86353				**	12		(12) FF 12-07-11	
Rubber Cushion													
D2265		Manufactured	No			160	Each	60.0000	1	12			
D2265									**				
Step Bracket													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST488		60				12		JMP	
				44114		60							
D2397-1		Manufactured	No			160	Each	1.0000	1	12			
D2397-1									**			(12) FF 12-07-11	
Rubber Cushion													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA	86354	1				12			
				72737		1							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Dart Aerospace Ltd

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NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86194 MLJ



12/06/22

RELEASED
98.12.14 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. E
BW	CP	HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 3
KE	CP	D2362	
DATE	TITLE	SCALE	
98.12.04	STEP SUPPORT BRACKET	1:2	
A	95.02.15	NEW ISSUE	
B	95.03.22	CHANGED RUBBER TO D2397	
C	96.01.22	ADD D2362-5	
D	97.05.21	ADD D2362-7	
E	98.12.04	REDRAWN, ADD 2397-5	

UNDER REVIEW

98.03.15 CP

DESIGN OK, BUT CHECK WITH
3B BEFORE MANUFACTURE
OK if mill. 9

REMOVE TIPS
FROM CASTING
MAX 0.080

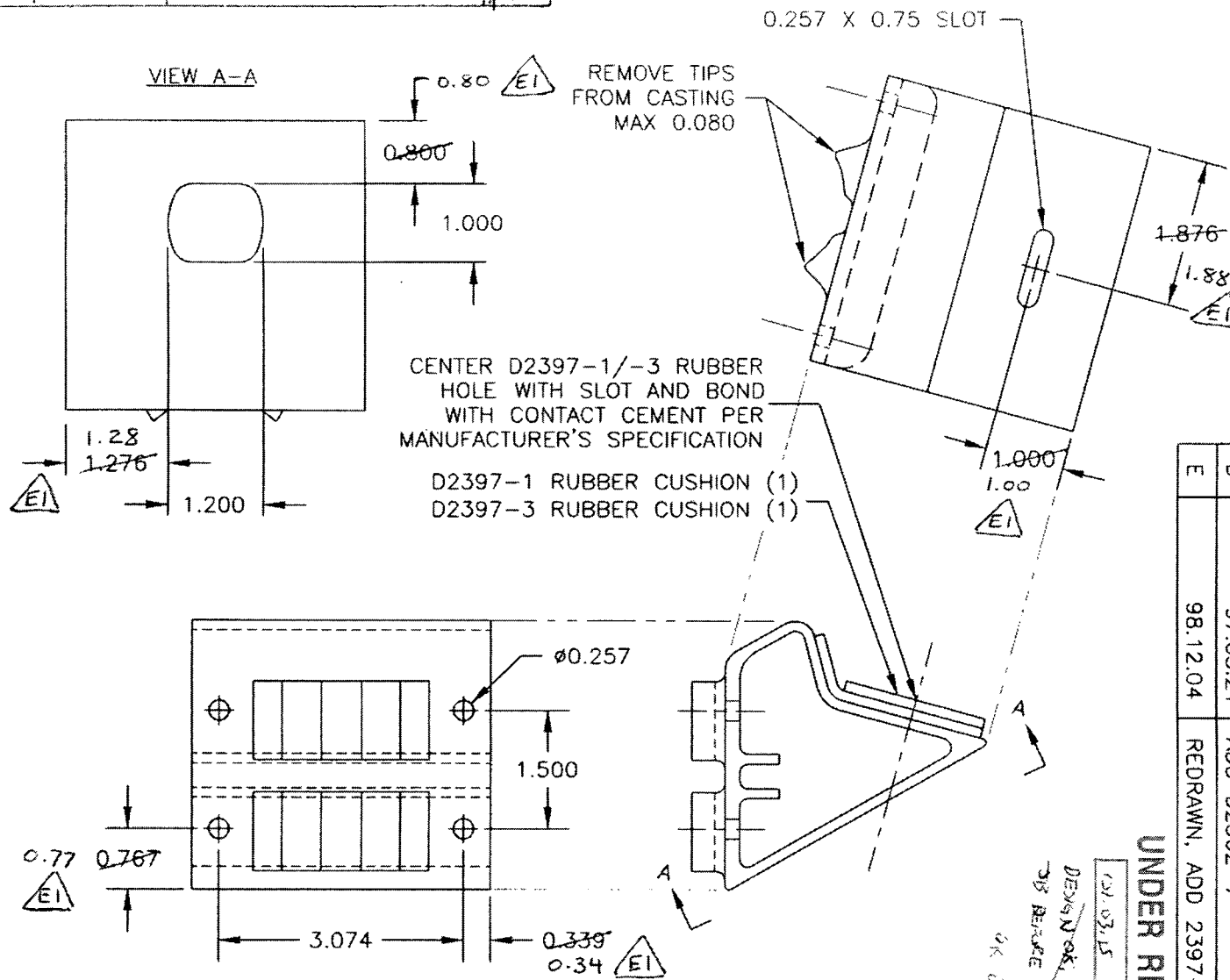
CENTER D2397-1/-3 RUBBER
HOLE WITH SLOT AND BOND
WITH CONTACT CEMENT PER
MANUFACTURER'S SPECIFICATION

D2397-1 RUBBER CUSHION (1)
D2397-3 RUBBER CUSHION (1)

D2362-3

EI 03.10.07 TOLERANCE CHANGE RT

VIEW A-A



NOTES:
MAKE FROM D2265
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING
RUBBER IN PLACE
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright 1995 by DART AEROSPACE LTD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

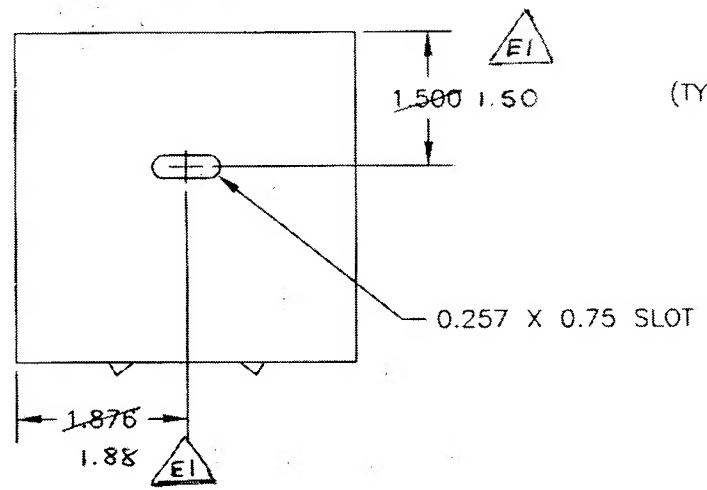
NOTE: Date & initial all entries

26194



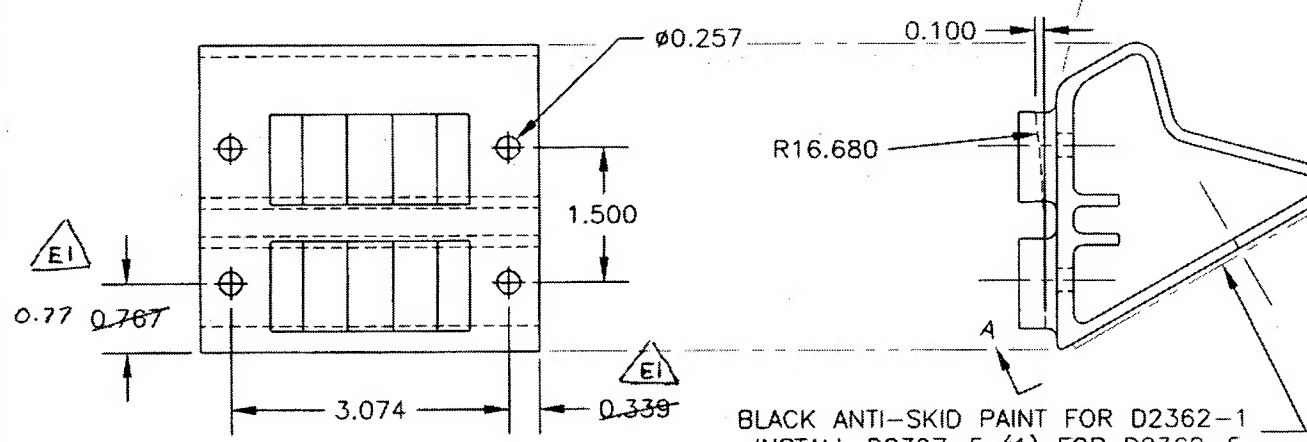
DESIGN	BW	DRAWN BY	CP	DART AEROSPACE LTD	REV. E
CHECKED	KE	APPROVED	KE	HAWKESBURY, ONTARIO, CANADA	SHEET 2 OF 3
DATE	98.12.04	TITLE	STEP SUPPORT BRACKET	SCALE	1:2

VIEW A-A



MACHINE TO R1.100 (TYP 2 PLACES)

REMOVE TIPS FROM CASTING MAX 0.080



BLACK ANTI-SKID PAINT FOR D2362-1
INSTALL D2397-5 (1) FOR D2362-5

D2362-1 & D2362-5

- NOTES:
- MAKE FROM D2265
 - D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
 - D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION
 - FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3
 - BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5
 - TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
UNDER REVIEW
98.12.14 KE

DESIGNED BY
D2362-5 CP
OR BEFORE MANUFACTURE
OK CP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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06194

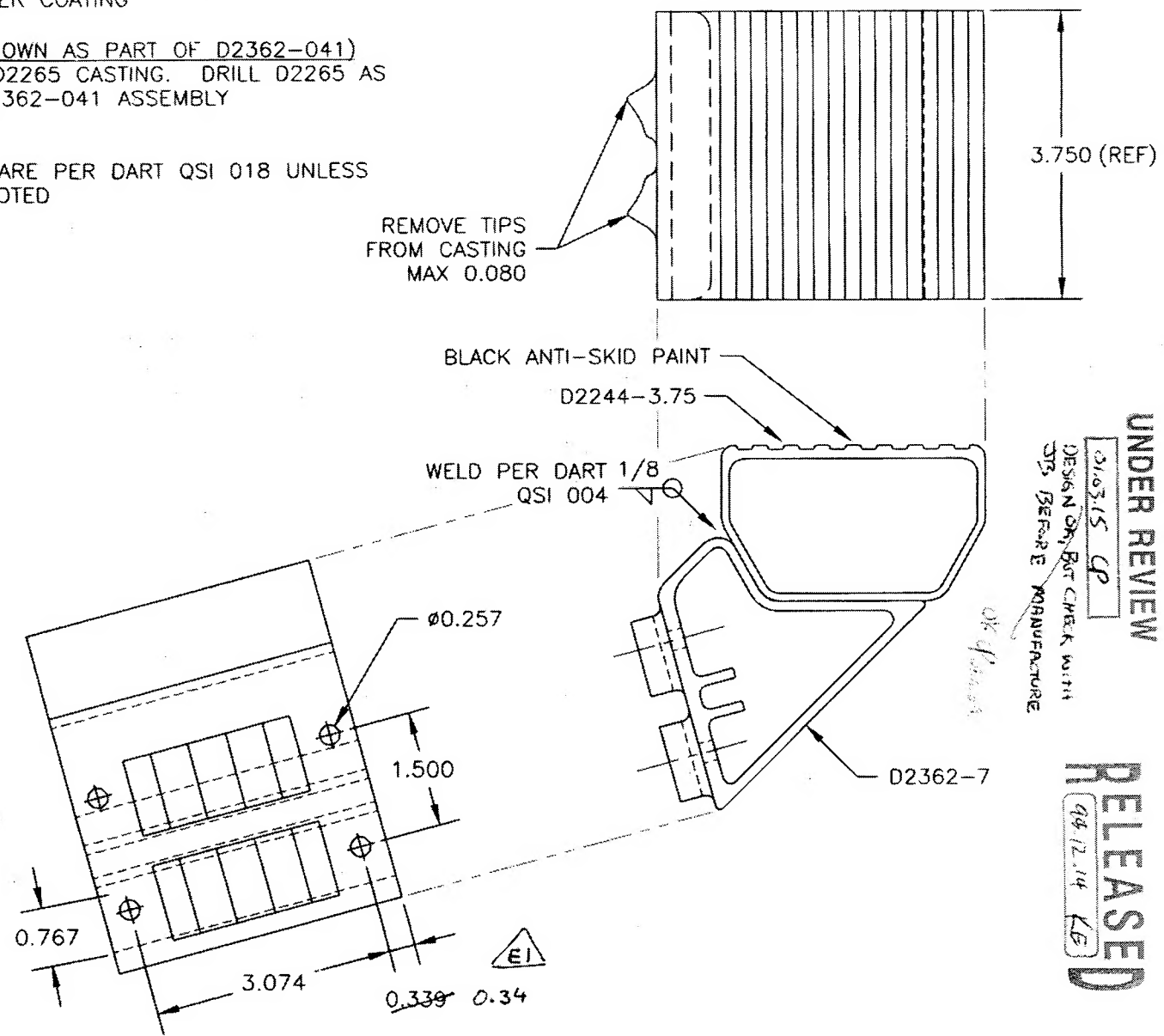


DESIGN BW	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED KE	APPROVED KE	REV. E
DATE 98.12.04	TITLE STEP SUPPORT BRACKET	SHEET 3 OF 3
		SCALE 1:2

UNDER REVIEW

RELEASED
98.12.14 KE

DESIGN OK BUT CHECK WITH
DTS BEFORE MANUFACTURE



D2362-041 (SHOWN)
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER
QSI 005 4.3
ANTI-SKID PIAINT PER QSI 005 4.4 AFTER
POWDER COATING

D2362-7 (SHOWN AS PART OF D2362-041)
MAKE FROM D2265 CASTING. DRILL D2265 AS
SHOWN IN D2362-041 ASSEMBLY

NOTES:
TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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